












Date: Thursday, 4/12/2007 8:21:55 AM  
User: Kim Johnston

## Process Sheet

pld 07-05/10

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 31657 -2		
Estimate Number	: 10283		
P.O. Number	: N/A	Part Number	: D31991
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D3199 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31426	Material	: N/A
Written By	: <u>07.04.12</u>	Due Date	: 4/30/2007 Qty: 30 Um: Each
Checked & Approved By	: <u>07.04.12</u>		
Comment	: Est Rev: C Removed Scribing 05-11-05 JLM Est Rev: D As per Rev B 06-11-24 JLM		

Additional Product

Job Number:			
Seq. #	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
			
Comment: Qty.: 0.1040 sf(s)/Unit Total: 3.1185 sf(s) 304/316 0.040" SHEET Batch: <u>M101873</u> <u>ml 07 05 10</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET Cut as per Dwg D3199 Dwg Rev: <u>B</u> <u>ml 07 05 10</u> Prog Rev: <u>B</u> <u>30</u>			
Deburr if required <u>mf 07-05-18</u> <u>24</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			<u>30</u>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 07 05 10</u>			
4.0	QC8	SECOND CHECK	
			<u>30</u>
Comment: SECOND CHECK <u>12/07/05/10</u>			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3199 <u>SB 07/05/22</u> <u>24</u>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/10	5	Spit w/o	SS	07/05/10	24		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

-NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31657

Part Number: D31991

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



07-05-23 (24)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

07-05-24 (24)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-05-24 (24)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57-24

07-05-24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-05-24 (24)

Job Completion



07-05-24

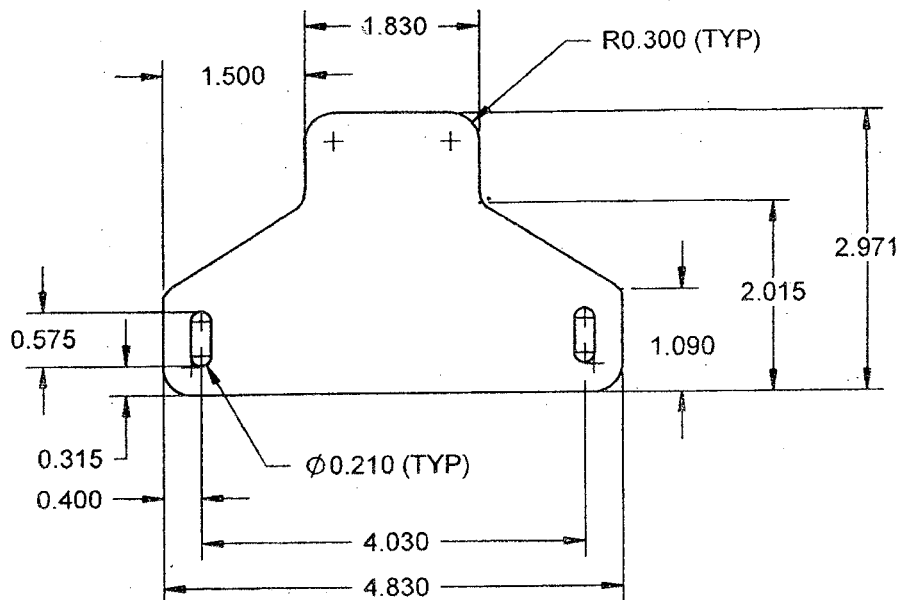
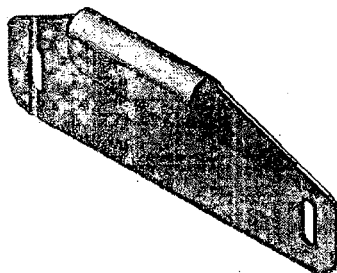




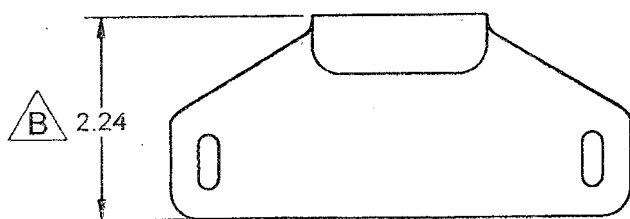
DESIGN 9P	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3199	REV. B SHEET 1 OF 1
DATE 06.11.01		TITLE BRACKET	SCALE 1:2
REV	DATE	DESCRIPTION	
A	03.08.05	NEW ISSUE	
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	

RELEASED

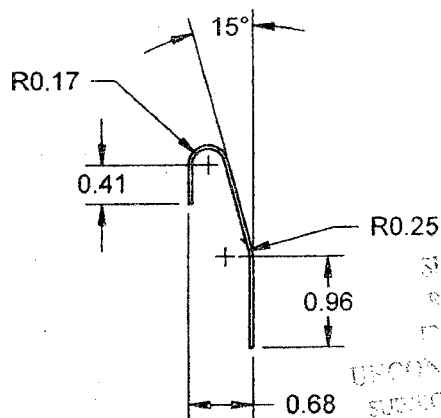
06.11.20 [Signature]



**D3199-1 FLAT PATTERN**



**D3199-1 BRACKET**



SHOP COPY  
RETURN TO  
DART AEROSPACE LTD  
UNCONTROLLED COPY  
SUBJECT TO AGREEMENT  
WITH DART AEROSPACE LTD  
NO. 31657

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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